



Dart Aerospace Ltd.
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K6A 1K7
Canada

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RBE350A93-1280-00

Job Sheet 198779



Part No: RBE350A93-1280-00

Job Qty: 2 pcs

Part Name: Bushing Replacement Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/6/19

Job Tracking No:

Due Date: 8/30/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBE350A93-1280-00 Rev 2 IPP Rev. A 19.04.25 New issue DP Verify DD

Ship Via:

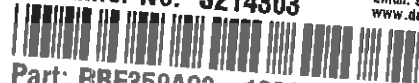
Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	2 pcs	8/30/19		0.00	0.40	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
110	QC 5	2 pcs	8/30/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	2 pcs	8/30/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



Container No: S214303



Part: RBE350A93 - 1280 - 00

Job No: 198779

Serial No/Batch: S214303

Revision: 2

Inspector:

Exp Date:

Instructions:

Date: 09/17/19

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SEP 17 2019

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				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - FG	2 pcs	8/30/19	0.00 0.00	QC 21 - FG - 21	Daram
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21

GA143

Part Op 100 - Assemble as per DWG. Use Loctite 495 to bond -07 to -01.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location;
 130 - QC21- Final Inspection - Work Order Release

SEP 18 2019

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
3896T31	Ferule 1/16 X 3/8" - Aluminum	4 Ea (2 ea)	100-Small Fab - 1	5199293
9381T22	S Hook Open End, Ø1/16 X 1	2 Ea (1 ea)	100-Small Fab - 1	5190004
CL-2-C	Lanyard Wire	2.3320 ft (1.166 ea)	100-Small Fab - 1	5184147
RBE350A93-1280-00-01	Block	2 pcs (1 ea)	100-Small Fab - 1	5188949
RBE350A93-1280-00-03	Pin	2 pcs (1 ea)	100-Small Fab - 1	5184575
RBE350A93-1280-00-07	Guide w/Adhesive Back	4 pcs (2 ea)	100-Small Fab - 1	5191617

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Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	3896T31	4	704	0
	9381T22	2	23	0
	CL-2-C	2	1,168	0
	RBE350A93-1280-00-01	2	8	0
	RBE350A93-1280-00-03	2	8	0
	RBE350A93-1280-00-07	4	4	0

Part Specifications

Specifications could not be found.

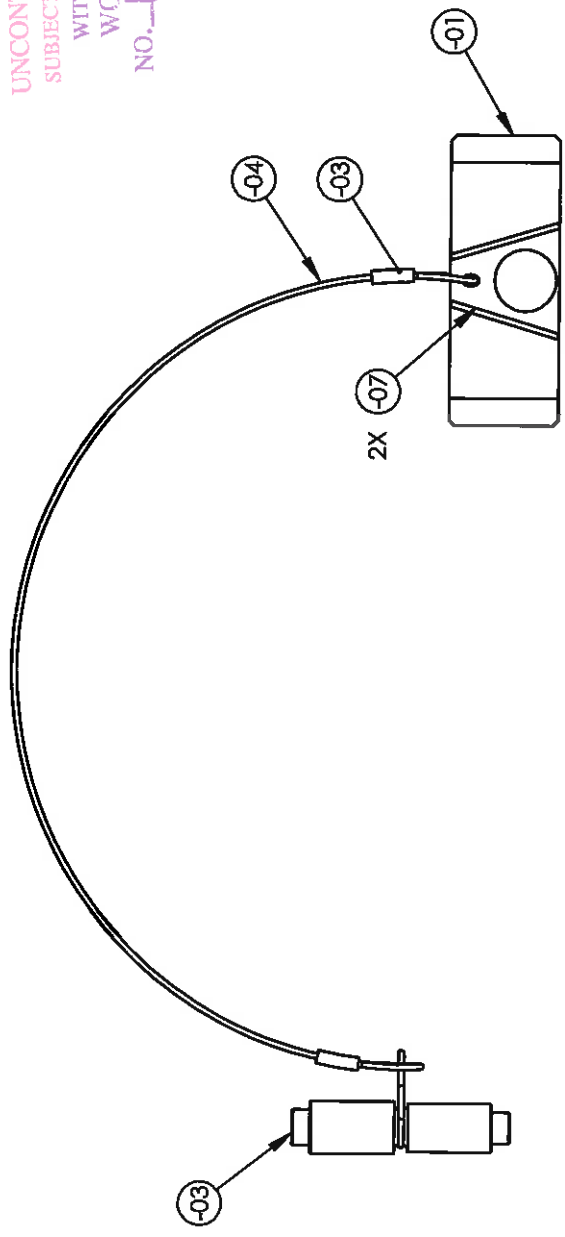
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
1	-1 BLOCK DIM. 539 WAS .540 AND DIM. 1.202 WAS 1.228 BECAUSE PLASTIC LINER THICKNESS WAS .072. NOW IS .042 DUE TO AVAILABILITY. DELETED GOTTIER PIN IN BLOCK FOR LANYARD.	11/11/2013	WP
2	CHD 17N AND NAME WAS RBEA93-1280-00 BUSHING REPLACEMENT TOOL IS RBE350A93-1280-00 TOOL REPLACEMENT BUSH OF REAR BLAD. -01 ADDED SECTION A-A AND CHD DIMENSION PLACEMENT TO CLARIFY FEATURE. -03 ADDED ALL MISSING RADIUS AND CHAMFER DIMENSIONS. -07 ADDED MISSING DRAWING.	11/11/2013	RJC

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RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198779 MJS
1908-06



RED BARN MACHINE									
TITLE									
TOOL, REPLACEMENT BUSH OF REAR BLAD									
DWG NO.		RBE350A93-1280-00						REV 2	
MTRL		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES				DRAWN BY: CLOUGH			
		.XXX ± .005 FRACTIONS ± 1/32				APPROVED <i>D Mott</i>			
		.XX ± .01 ANGLES ± 5°				HEAT TREAT			
		.X ± .1				FINISH			
		1. BREAK ALL SHARP EDGES .015 x 48°				SPEC			
		2. DIMENSIONAL LIMITS APPLY AFTER PLATING				USED ON MODEL			
						AS350			
SCALE		1:2		DATE		11/11/2013		SHEET 1 OF 4	
PG.		B/O INFORMATION OR SPECIFICATIONS							
		1		BLOCK		1 X 1-1/4 X 3-1/4		2	
		1		PIN		Ø5/8 X 2-1/2		3	
B/O		-04		LANYARD		COATED STEEL		1	
B/O		-05		FERRULE		Ø1/16 X 3/8 MCMASTER-CARR #3896731		1	
		-07		GUIDE W/ADHESIVE BACK		1/16 X 3/16 X 1-1/4		4	
B/O		-09		S HOOK OPEN END		Ø1/16 X 1 MCMASTER-CARR #9381722		1	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ ☐ ☐ Scrap ☐ ☐ ☐ Use-as-is ☐ ☐ ☐		DEPARTMENT/PROCESS Cross tube ☐ ☐ ☐ Eng. (Non-AW) ☐ ☐ ☐ Machining ☐ ☐ ☐ Prod. Eng. Coord. ☐ ☐ ☐ Large Fab ☐ ☐ ☐ Rec/Store/Packaging ☐ ☐ ☐		Engineering ☐ ☐ ☐ Water Jet ☐ ☐ ☐ Supplier ☐ ☐ ☐ Quality ☐ ☐ ☐	
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QS1042) _____	
Description Work Order Deviation				Disposition			
Root Cause Operator ☐ ☐ ☐ ☐ ☐ Manufacturing Process ☐ ☐ ☐ ☐ ☐ Equip/Tooling ☐ ☐ ☐ ☐ ☐ Handling/Preservation ☐ ☐ ☐ ☐ ☐ Material ☐ ☐ ☐ ☐ ☐ Product Improvement ☐ ☐ ☐ ☐ ☐ Process Improvement ☐ ☐ ☐ ☐ ☐ Human Factors ☐ ☐ ☐ ☐ ☐				FAULT CATEGORY Contamination ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Misaligned/off center ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ BOM/Route ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Broken/Damage/Defect ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Incomplete/Unclear Instructions ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Drill Holes ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Fit/Function ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐			
				Power Loss/Surge ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Folio/Program ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Grain Direction ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Weld ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Wrong Stock Pulled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Out of Sequence ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Off-set/Set-up ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐			
Pressure/Forced ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Bending ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Crushing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Cracks ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Marks/Chatter ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Mislabeled ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐				Positioned Wrong ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Outside Tolerance ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Drawing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Finish ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Part Lost/Missing ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ Misread ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐ ☐			
Other/Details: _____				Completed By _____ Lead hand / Supervisor _____ QC / QA Coordinator _____			